

Work Order ID 147997

Wednesday, June 22, 2016 8:36:58 AM

147997

Page 1

Item ID: D3220-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler Assembly
 Start Date: 6/8/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 6/17/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3220	B								

100

0.09

100

FLOW WATER JET

Waterjet

Memo

0.03

FLOW CNC Waterjet

1-Cut D3220-1 as per Dwg D3220 Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.01

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.01

Quality Control

PR 2016/06/26

PR 2016/06/26

6

DAS
38
9-89

JUL 04 2016

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Item ID: D3220-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler Assembly

Start Date: 6/8/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/17/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>SH485</u>	0.00							
190									
Packaging	Memo	0.01							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.07							
Quality Control									

DAS
21
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Picklist Print

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Work Order ID: 147997

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Parent Item: D3220-041

D3220-041

Parent Item Name: Doubler Assembly

Start Date: 6/8/2016

Required Date: 6/17/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 05-11-06 JLM
IPP: B 06.11.15 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050		Purchased	No			100	sf	59.8000	0.6926	2.916210			
										**	PR 2016/06/26		
M2024T3S 050													
2024-T3 .050 sheet													

Location	Loc Qty	Loc Code
MAT022	59.8	
m131564	24.2	
m134581	35.6	

4.4

MS20426AD3-3		Purchased	No			170	Each	1,385.000	8	32			
										**	16/07/11 DAS 36 9-89		
MS20426AD3-3													
RIVET													

Location	Loc Qty	Loc Code
GA	462	
M131624	462	
ST312	923	
M131624	923	

48

MS21059L4		Purchased	No			170	Each	38.0000	4	16			
										**	16/07/11 DAS 36 9-89		
MS21059L 4													
Nutplate													

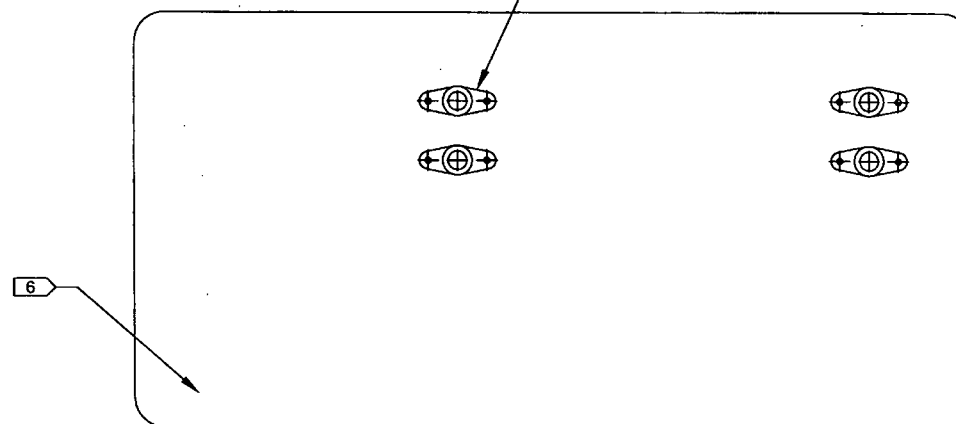
Location	Loc Qty	Loc Code
ST301	38	
m133483	4	
m134474	9	
m134962	25	

15

135133 (94)

Item	Qty -041	Qty -042	Part Number	Description
1	X		D3220-041	DOUBLER ASSEMBLY
2		X	D3220-042	DOUBLER ASSEMBLY
3	1		D3220-1	DOUBLER
4		1	D3220-2	DOUBLER
5	4	4	MS21059L4	NUTPLATE
6	8	8	MS20426AD3-3	RIVET

B
MS21059L4 NUTPLATE
MS20426AD3-3 RIVET, 2X
4 PL



D3220-1/2 DOUBLER

**D3220-041 DOUBLER ASSEMBLY (SHOWN WITH D3220-1 DOUBLER)
D3220-042 (OPPOSITE)**

STOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

147992 MWS

16-06-21

RELEASED
2009-09-09

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3220-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3220-041 = 0.53 lbs
D3220-042 = 0.53 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS. Ø0.316 WAS Ø0.323 (ZN C8-2, B4-3); MS20426AD3-3 WAS MS20426AD3-4 (ZN D4-1); CORRECT TYPO NOTE 1 (ZN A8-2, A8-3); REF PAR 09-025	RF	09.07.08
A	NEW ISSUE	CP	03.10.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3220	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

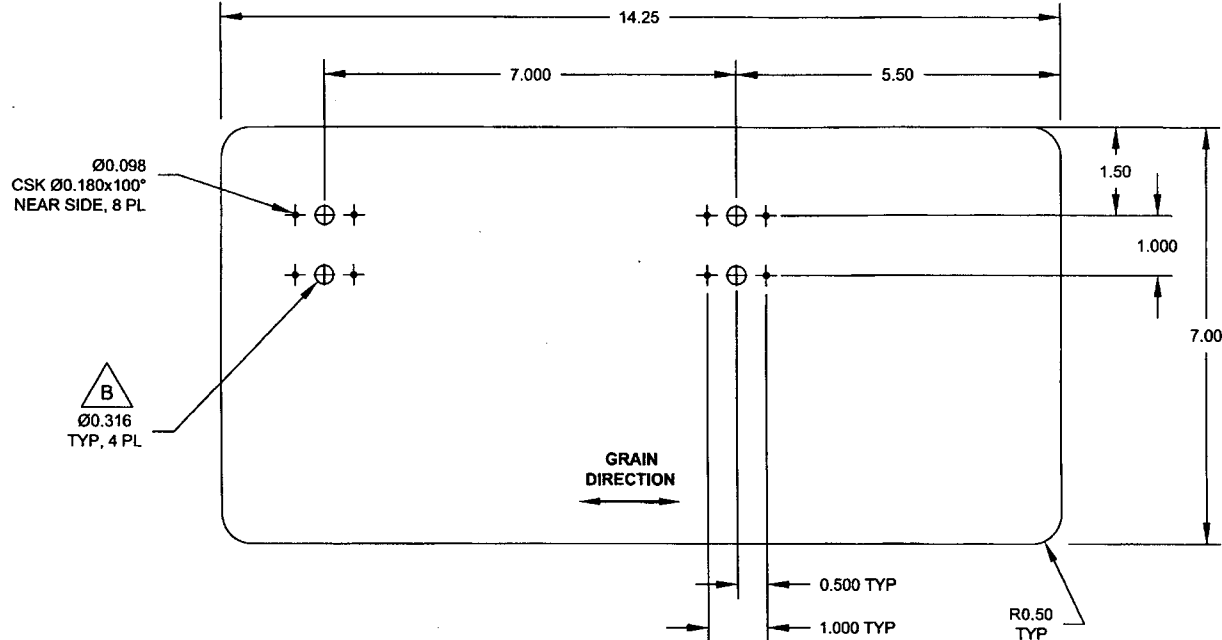
8 7 6 5 4 3 2 1

D

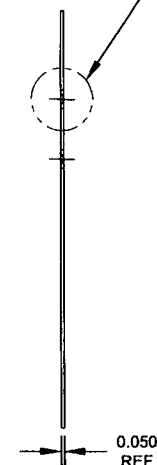
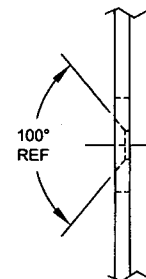
C

B

A



B1-2
SEE DETAIL A
TYP



DETAIL A
SCALE 5X

D3220-1 DOUBLER

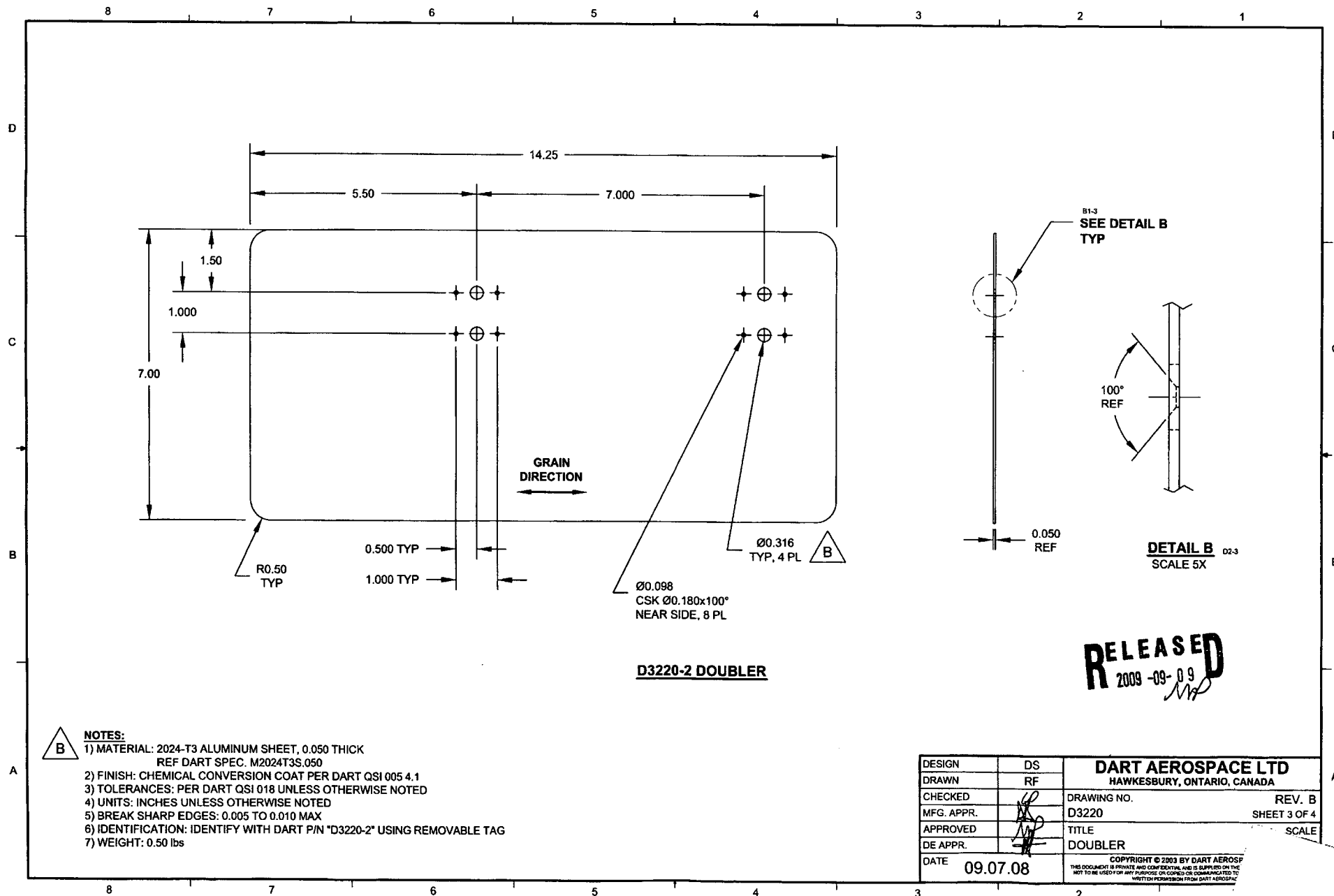
RELEASED
2009-09-03
no

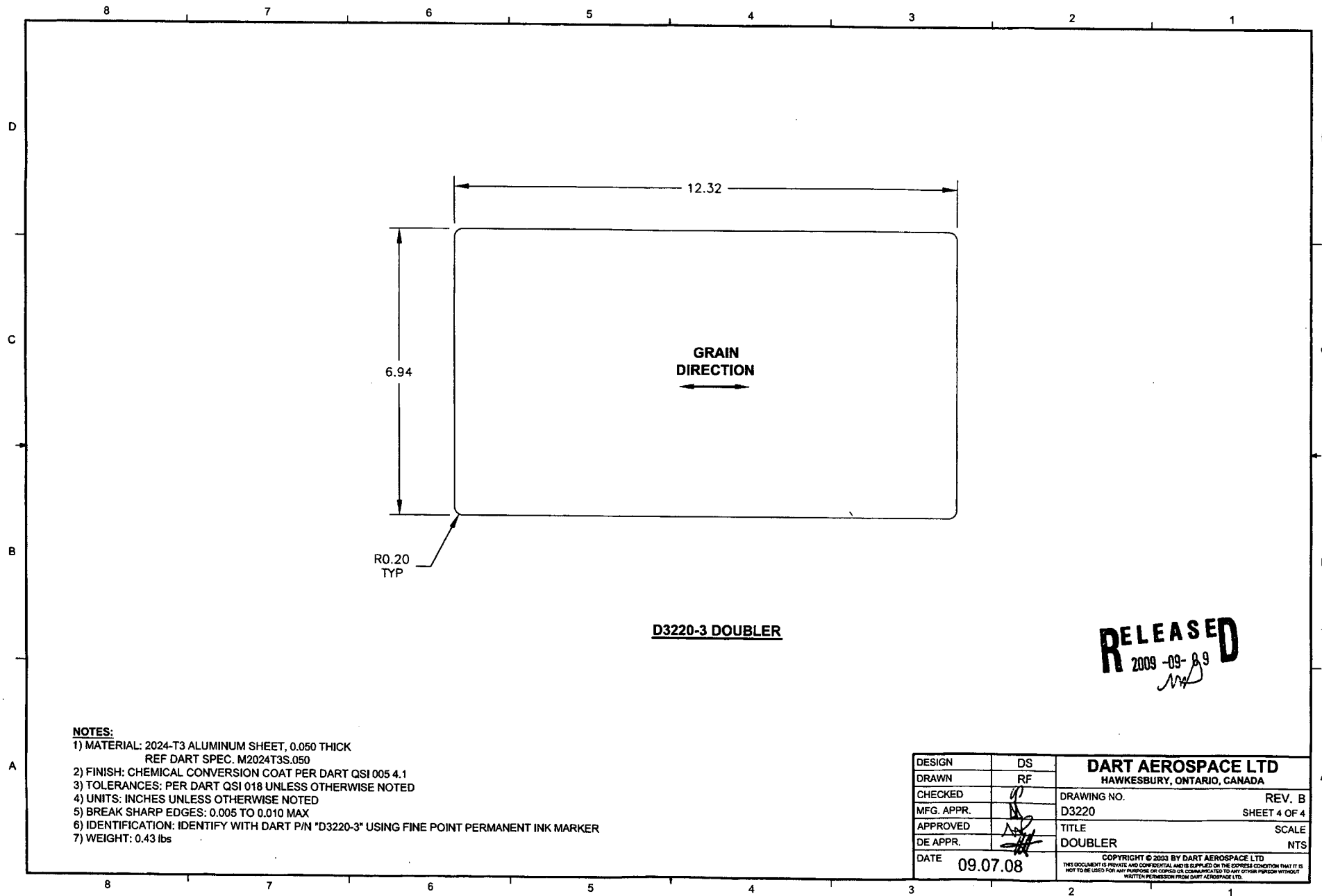
NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
REF DART SPEC. M2024T3S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3220-1" USING REMOVABLE TAG
- 7) WEIGHT: 0.50 lbs

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MFG. APPR.	<i>[Signature]</i>	D3220	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLER	NTS
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8 7 6 5 4 3 2 1





D3220-3 DOUBLER

RELEASED
2009-09-09

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
REF DART SPEC. M2024T3S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3220-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.43 lbs

DESIGN	DS	DART AEROSPACE LTD	
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MFG. APPR.	<i>[Signature]</i>	D3220	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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